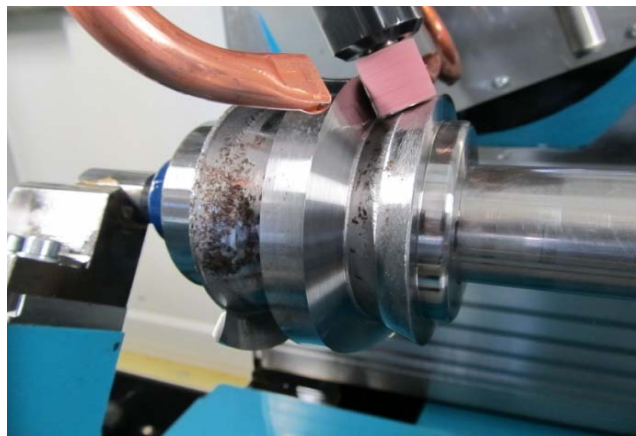











## Globoidal Cam Ø98 L50

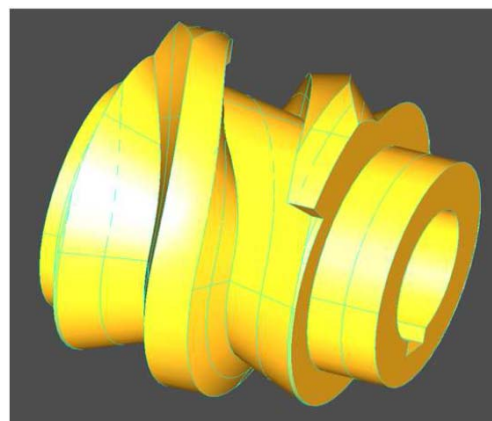
A40-900

For material removal of 0.5 mm pregrinding and finishing is required: 10 roughing passes à 0.05 and 2 finishing passes à 0.005 mm. A hf-spindle for higher rpm's is recommended for a production machine using permanently small finger-wheels.



### 1. Cycletime for Production

Workpiece: Ø98 L50 Material HSS					
Operations					
Feed [mm/Min]	2000	350	350	450	450
Power [kW]		2	2	1	1
Cutting speed [m/s]		26	26	26	26
Used wheels					
Grinding time [s]	15	339	339	82	82
Total cycle time	14 Min 16				



The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	1A1 Ø12 B126
2	1A1 Ø12 B76



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR

Control: Fanuc 31i

Accessories: hf spindle

Responsible engineer: OP. 3.12.13

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

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